

Order 2159

Ship 7 Nov



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D117-1044-013
Job Sheet 183883



Part No: D117-1044-013

Job Qty: 1 ea

Part Name: H145 Quick Release Heli-Utility-Basket™ Prop Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/27/18

Job Tracking No:

Due Date: 11/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D117-1044 REV.B IPP REV:A 18.01.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/7/18	11/7/18	0.00	0.00	Start Up Stores/Pkg-1	6.89 DAS	OCT 23 2018
110	Packaging	1 pcs	11/7/18	11/7/18	0.00	0.00	Packaging1-1	6.89 DAS	OCT 23 2018
130	QC	1 pcs	11/7/18	11/7/18	0.00	0.00	QC4	6.89 DAS	OCT 23 2018
135	DC	1 pcs	11/7/18	11/7/18	0.00	0.00	DC	6.89 DAS	OCT 24 2018
140	Packaging	1 pcs	11/7/18	11/7/18	0.00	0.00	Packaging3-1	6.89 DAS	OCT 23 2018
150	QC21-FG	1 Ea	11/7/18	11/7/18	0.00	0.00	QC21	6.89 DAS	OCT 24 2018

Part Op 135 - Photocopy bluefile & type labels per PPP D117-1044-013 CHG 001

Descriptions: 140 - Identify and pack for shipping as per PPP D117-1044-013 Location: _____ PPP Rev: 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2332-041	Lid Prop Assembly 6.69"	1 Ea (1 ea)	90-Start up Operation	50913306
MS24665-300	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	5104465

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2332-041	1	3	0
	MS24665-300	2	128	0

Part Specifications



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7/18 3:08 PM Dart.lajeunesse.marie

Container No: S120678



Part: D117-1044-013

Job No: 183883

Serial No/Batch: S120678

Revision: B

Inspector:

Exp Date:

Instructions: FAA STC SR02578SE 17/12/13, EASA STC 100

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the Heli-Utility-Basket™ kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D117-1044-011/-012 (Heli-Utility-Basket™, LH/RH Install)	134 lb 60.8 kg	+/-40.5 in +/-1.03 m	+/-5427 in-lb +/-62.6 m-kg	167 in 4.24 m	22378 in-lb 257.8 m-kg
D117-1044-111 (Crosstube Adapter Kit, Install)	3.5 lb 1.6 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	165.5 in 4.20 m	579 in-lb 6.7 m-kg
D117-1044-113/-114 (QR Basket Mounting Provision Kit, LH/RH Install, includes D117-1044-111 Crosstube Adapter kit above)	56 lb 25.4 kg	+/-14.7 in +/-37 m	+/-823 in-lb +/-9.4 m-kg	167 in 4.24 m	9352 in-lb 107.7 m-kg

5.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -111	Qty -113	Qty -114	Part Number	Description
X						D117-1044-011	HELI-UTILITY-BASKET, LH
	X					D117-1044-012	HELI-UTILITY-BASKET, RH
		X				D117-1044-013	PROP ARM KIT (OPTIONAL)
			X	1	1	D117-1044-111	CROSSTUBE ADAPTER KIT
1				X		D117-1044-113	QR BASKET MOUNTING PROVISION KIT, LH
	1				X	D117-1044-114	QR BASKET MOUNTING PROVISION KIT, RH
		1*				D2332-041	PROP ASSEMBLY (OPTIONAL)
1						D5067-011	BASKET ASSEMBLY, HEAVY DUTY, LH
	1					D5067-012	BASKET ASSEMBLY, HEAVY DUTY, RH
			4			D5069-1	HARDPOINT ADAPTER
1	1					D5203-043	STRUT ASSEMBLY
				1		D5549-011	FWD BEAM ASSEMBLY, LH
					1	D5549-012	FWD BEAM ASSEMBLY, RH
				1		D5549-013	AFT BEAM ASSEMBLY, LH
					1	D5549-014	AFT BEAM ASSEMBLY, RH
			1			D5612-041	ADAPTER WRENCH
			4			DIN65270-12D	NUT
			4			EN2367-23025	PIN, COTTER
		2*				MS24665-300	COTTER PIN

* D2332-041 PROP ASSEMBLY & HARDWARE (OPTIONAL) TO REPLACE D3969-3 GAS SPRING

Change Record

PAGE 1 OF 1

Part Number: D117-1044-013

Description: PROP ARM INSTALLATION (OPTIONAL)

[illegible]